



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D350-748-243TRN
Job Sheet 173670



Part No: D350-748-243TRN

Job Qty: 1 ea

Part Name: Crosstube Installation, High Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV A IPP Rev: PRELIM New Issue LL 12.05.08

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/17/18	0.00	0.00	Start Up Crosstubes-1		
100	Mori Seiki	1 pcs		4/17/18	2.01	3.57	Mori Seiki TL-40		
110	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		
120	Mori Seiki	1 pcs		4/17/18	0.00	3.57	Mori Seiki TL-40		
130	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		
140	QC	1 pcs		4/17/18	0.00	0.00	QC8		
150	Crosstubes	1 pcs		4/18/18	0.00	0.81	Crosstubes-2		
190	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging3-1		
200	QC21-SA	1 Ea		4/18/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut tube on chop saw, leave extra mat'l for facing and install plugs 350-241 on both ends. 3- Turn program 02000
Descriptions: section on both side as per folio FB468. 4- Turn program 03000 section on both side as per folio FB468.

120 - 1- Turn program 04000 section on both side as per folio FB468. 2- Turn program 05000 section on both side as per folio FB468. 3- Blend transition lines only with belt sander 60 grit 4-Scribe part # as per Dwg D350-748-243

130 - PERFORME ULTRASONIC MEASUREMENT

150 - 1-Grind machining marks

190 - Identify and stock in kanban rack

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6021-125	Crosstube Material - 17-4Ph SS	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6021-125	1	71	0

B127 272

Part Specifications

Specifications could not be found.

Plex 3/6/18 12:34 PM Dart.Gagnon.Michelle



Container No: S071063



Part: D350-748-243TRN

Job No: 173670

Serial No/Batch: S071063

Revision:

Inspector:

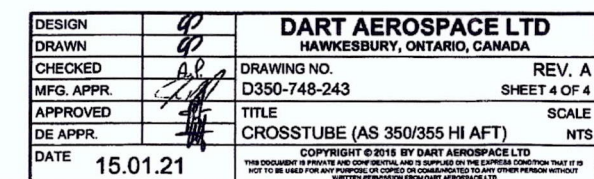
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/14/10



05/14/10

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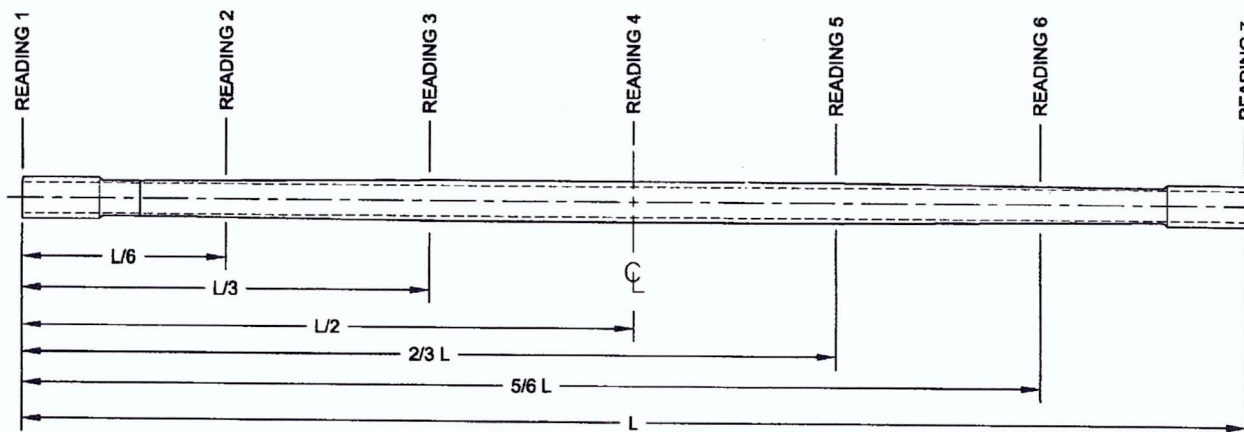
DART AEROSPACE LTD	Work Order:	<i>173670</i>
Description: Crosstube Assembly (AS350/355 High Aft SS)	Part Number:	D350-748-243
Inspection Dwg: D350-748-243 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+/-0.005					
	2.180	+0.005/-0.000					
	2.180	+0.005/-0.000					
	2.208	+0.005/-0.000					
	2.234	+0.005/-0.000					
	2.253	+0.005/-0.000					
	2.272	+0.005/-0.000					
	2.299	+0.005/-0.000					
	0.063	+/-0.010					
	5.25	+/-0.060					
	R0.063	+/-0.010					
	R0.50	+/-0.030					
SIDE B	2.240	+/-0.005					
	2.180	+0.005/-0.000					
	2.180	+0.005/-0.000					
	2.208	+0.005/-0.000					
	2.234	+0.005/-0.000					
	2.253	+0.005/-0.000					
	2.272	+0.005/-0.000					
	2.299	+0.005/-0.000					
	0.063	+/-0.010					
	5.25	+/-0.060					
	R0.063	+/-0.010					
	R0.50	+/-0.030					
	124.70	+/-0.060					

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"						0.030"
READING 2 L=						
READING 3 L=						
READING 4 L=						
READING 5 L=						
READING 6 L=						
READING 7 L=						

Calibration Result

Actual Block Thickness: _____

Sitiescan 250 Measured Thickness: _____

Measured by: _____		Audited by: _____		Preliminary Approval: _____	
Date: _____		Date: _____		Date: _____	

Rev	Date	Change	Revised By	Approved
A	15.09.09	New Issue (P/O D350-748-203)	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☒</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☒	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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Date: 2018/05/17		Step #: 1012		QTY Effective: 21		MRB (QSI042) Approval																																																																											
Description Work Order Deviation				Disposition		8/18/17																																																																											
Operator went in wrong direction with tool during Manual operation. tube gauged beyond repair. Re. operator to set origin correctly. No Reverification				SCRAP 4/18/5/7 Destroy No Replace		Completed By																																																																											
						DAS 56																																																																											
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